

Work Order ID 117272

May-15-14 1:08:07 PM

117272

Rev & Day. 5/15/14
PRELIMINARY ISSUE

Page 1

Item ID: D2263-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp
 Start Date: 5/15/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 2.00 *2* Customer:
 Reference: rework PD1

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2263	PD1 Rev D 5/15/14

130 Small Fab 0.00

130

Small Fab

Small Fab

Memo

PULL FROM STK:
2 X D2263-1 B16735 15445

APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI005 4.9
B 121098

140 QCS- Inspect part completeness to step on W/O 0.00

140

QC

Quality Control

Memo

SHP
4/5/16

2
Inspect as per
Rev PD1

CL 14-05-16

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Page 2

Item ID: D2263-3 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SHIP TO

DAVID S.

14/9/9

mf 14-5-16

POSITIVE RECALL
 EFFECTIVE 4/05/15 AUTH h
 RELEASED 14/09/13 DATE 5

to Rev D Dry only

Picklist Print

Page 1

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Work Order ID: 117272

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Parent Item: D2263-3

D2263-3

Parent Item Name: Clamp

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B01.06.08Now laser cutEC IPP REV:C 14.05.13 NOW
TEXTURE COATING DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2263-3		Manufactured	No				Each	177.0000		2			

D2263-3

Clamp

Location

Loc Qty

Loc Code

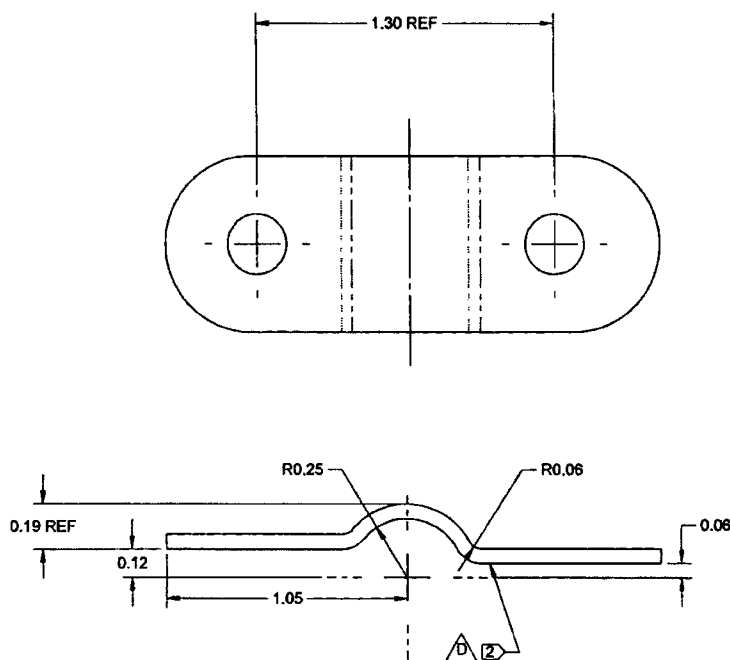
Mezz

177

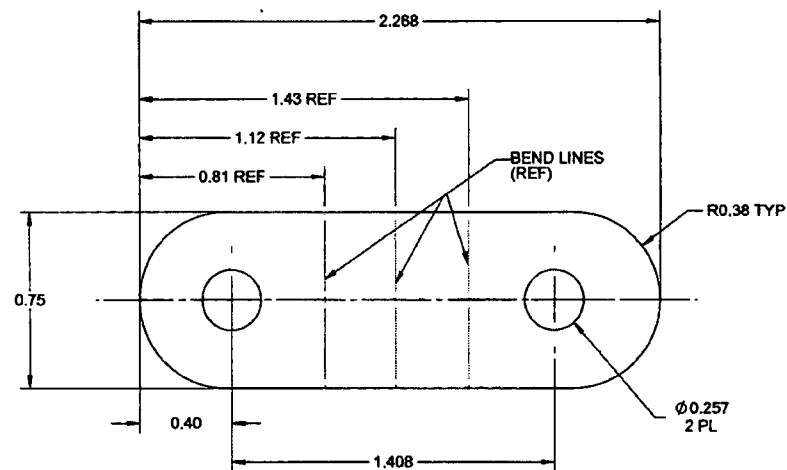
15445

177

2



D2263-1 CLAMP



D2263-1F FLAT PATTERN

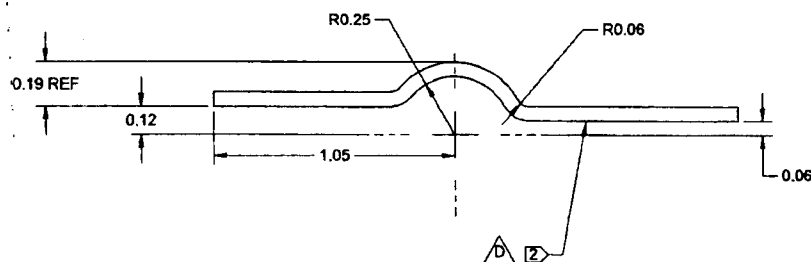
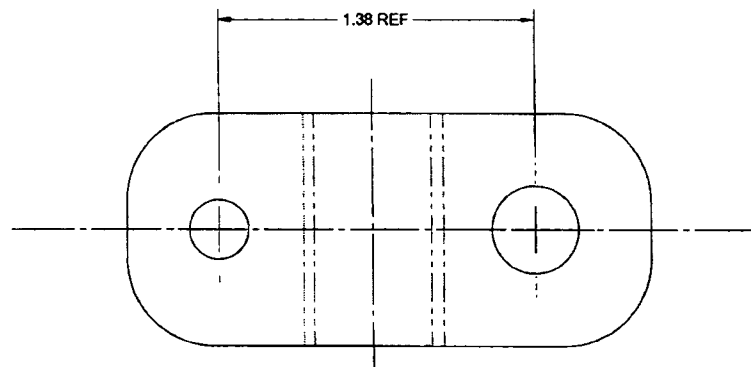
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063 THICK, (REF DART SPEC M304S16GA)
- 2) FINISH: APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-1" PER QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

D	RE-FORMAT DWG, ADD NOTE 2 (TEXTURED COATING)	DB	14.04.28
C	CREATE D2263-11-3	HS	01.03.13
B	REDRAWN	HS	99.06.08
A	NEW ISSUE	JB	94.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2263	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
DATE	14.04.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED

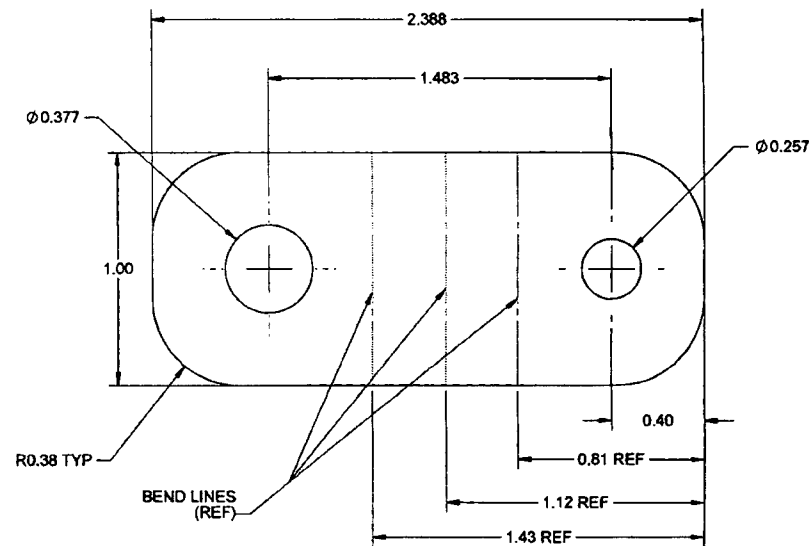
WLB
a 7272



D2263-3 CLAMP

NOTES:

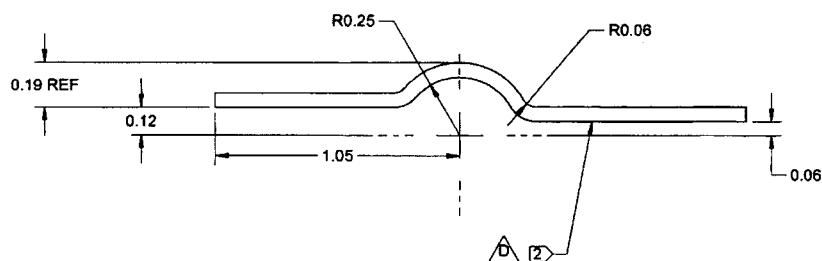
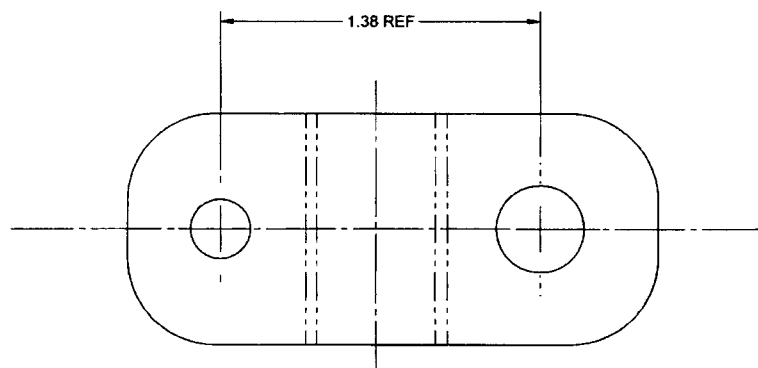
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-3" PER QSI 044 6.7
- 7) WEIGHT: 0.08 lbs



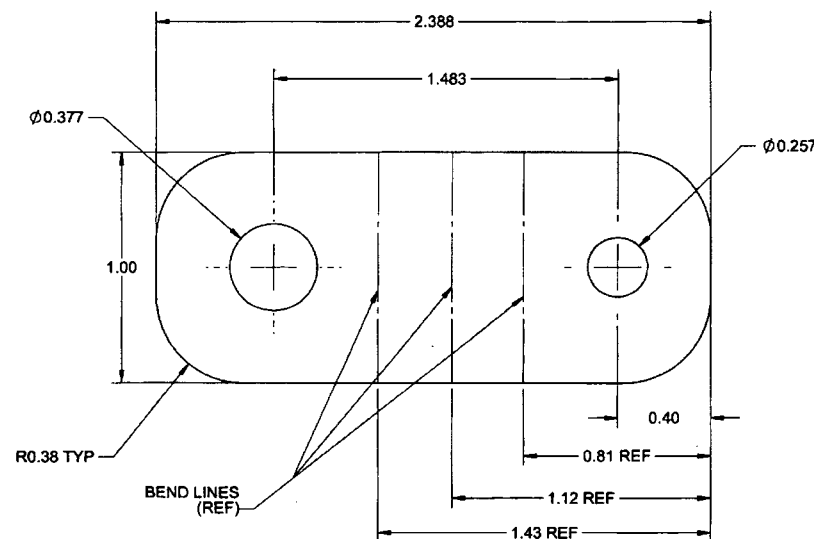
D2263-3F FLAT PATTERN

APPROVED

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2263	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D2263-3 CLAMP



D2263-3F FLAT PATTERN

RELEASED
2014-08-27

- NOTES:**
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DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2263	SHEET 2 OF 2
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